

Work Order ID 77699

77699

Page 1

Friday, December 16, 2011 12:51:31 PM

Item ID: D3463-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment Assembly

Start Date: 12/16/2011 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/6/2012 Req'd Qty: 4.00 ***4*** Customer:

Reference:

Approvals: Process Plan: *R* Date: *11-12-16* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3463 | Rev B |

| | | | | | | | | | |
|--------------|---|------|--|--|--|--|--|--|--|
| 100 | Large Fab | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | Weld assembly as per dwg D3463 using DT8875 | | | | | | | | |

| | | | | | | | | | |
|-----------------|--|------|--|--|--|--|--|--|--|
| 110 | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

| | | | | | | | | | |
|-----------------|---|------|--|--|--|--|--|--|--|
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

12-2-10 *(2)*

Pl 12.03.13

24

8/26/12

(2)
041

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

776.99

Friday, December 16, 2011 12:51:31 PM

N900040100

Setup Start *NS1*

Stop *NS2*

4

Cust Item ID:

4

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

[illegible]

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Memo

0.00

Powdercoat

1- Mask areas indicated on dwg D3463 (holes, threads)
START TIME: 1:40
OVEN TEMPERATURE: 400
FINISH TIME: 2:00

140

Wing Walk as per dwg QSI005 4.4 Batch M119090100

140

Memo

0.00

HandFinish

Hand Finishing

150

QC3- Inspect Part Finish

0.00

150

Memo

0.00

OC

Quality Control

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 | Identify as per dwg & Stock Location: <u>GA</u> | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |
| 170 | QC21- Final Inspection - Work Order Release | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

EP 12/02/14

12/2/15

*12-02-11
G*

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, December 16, 2011 12:51:35 PM

Work Order ID: 77699

77699

Parent Item: D3463-041

D3463-041

Parent Item Name: Step Weldment Assembly

Start Date: 12/16/2011

Required Date: 1/6/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.18 new issue EC IPP revB: replace pressure
with wing walk DD 10.01.28 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| 238-806 | | Purchased | No | | | 100 | Each | 64.0000 | 2 | 8 | | | |
| *238-806* | | | | | | | | | ** | | | EQ 12-2-10 | |
| SS DOWEL PIN 1" LONG | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST399 | | 64 | | | | | | | |
| | | | | 117606 | | 64 | | | | 4. | | | |
| D3453-3 | | Manufactured | No | | | 100 | Each | 12.0000 | 1 | 4 | | | |
| *D3453-3* | | | | | | | | | ** | | | EQ 12-2-10 | |
| Clevis | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA022 | | 12 | | | | | | | |
| | | | | 71900 | | 4 | | | | | | | |
| | | | | 73622 | | 8 | | | | | | | |
| D3453-5 | | Manufactured | No | | | 100 | Each | 11.0000 | 1 | 4 | | | |
| *D3453-5* | | | | | | | | | ** | | | EQ 12-2-10 | |
| Plug | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA022 | | 11 | | | | | | | |
| | | | | 59204 | | 1 | | | | | | | |
| | | | | 73623 | | 10 | | | | | | | |
| D3463-1 | | Manufactured | No | | | 100 | Each | 4.0000 | 1 | 4 | | | |
| *D3463-1* | | | | | | | | | ** | | | EQ 12-2-10 | |
| Arm | | | | | | | | | | | | | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA030 | | 4 | | | | | | | |
| | | | | 70855 | | 4 | | | | | | | |
| | | | | 78211 | | x 2 | | | | | | | |

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

Friday, December 16, 2011 12:51:35 PM

Work Order ID: 77699

77699

Parent Item: D3463-041

D3463-041

Parent Item Name: Step Weldment Assembly

Start Date: 12/16/2011

Required Date: 1/6/2012

Start Qty: 4.00

Required Qty: 4.00

D3463-3 Manufactured No

100 Each 12.0000 1 4

D3463-3

Step

78886 X 2

Location

Loc Qty

Loc Code

WA023

12

46269

12

D3463-5 Manufactured No

100 Each 21.0000 2 8

D3463-5

End Cap

78213 X 4

Location

Loc Qty

Loc Code

WA023

21

70819

21

D3463-7 Manufactured No

100 Each 11.0000 1 4

D3463-7

Drag Arm

Location

Loc Qty

Loc Code

WA

10

WA025

1

70857

1

73624

10

78202

X 2

Friday, December 16, 2011 12:51:35 PM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

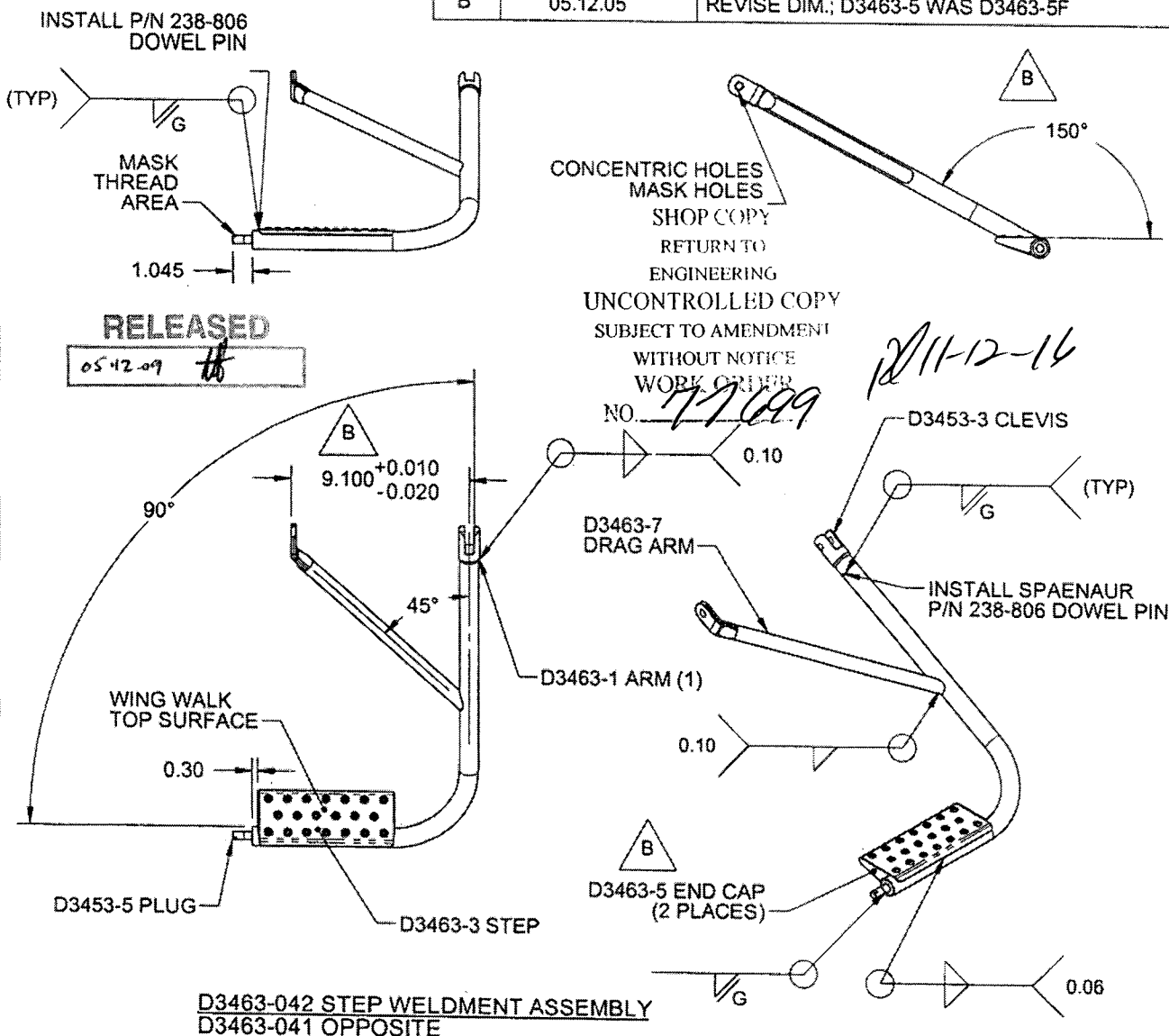
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



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|-------------------------|----------------|--|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3463 | REV. B SHEET 1 OF 4 |
| DATE 05.12.05 | | TITLE STEP WELDMENT | SCALE 1:8 |
| A | 05.09.20 | NEW ISSUE | |
| B | 05.12.05 | REVISE DIM.; D3463-5 WAS D3463-5F | |



NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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Dart Aerospace Ltd

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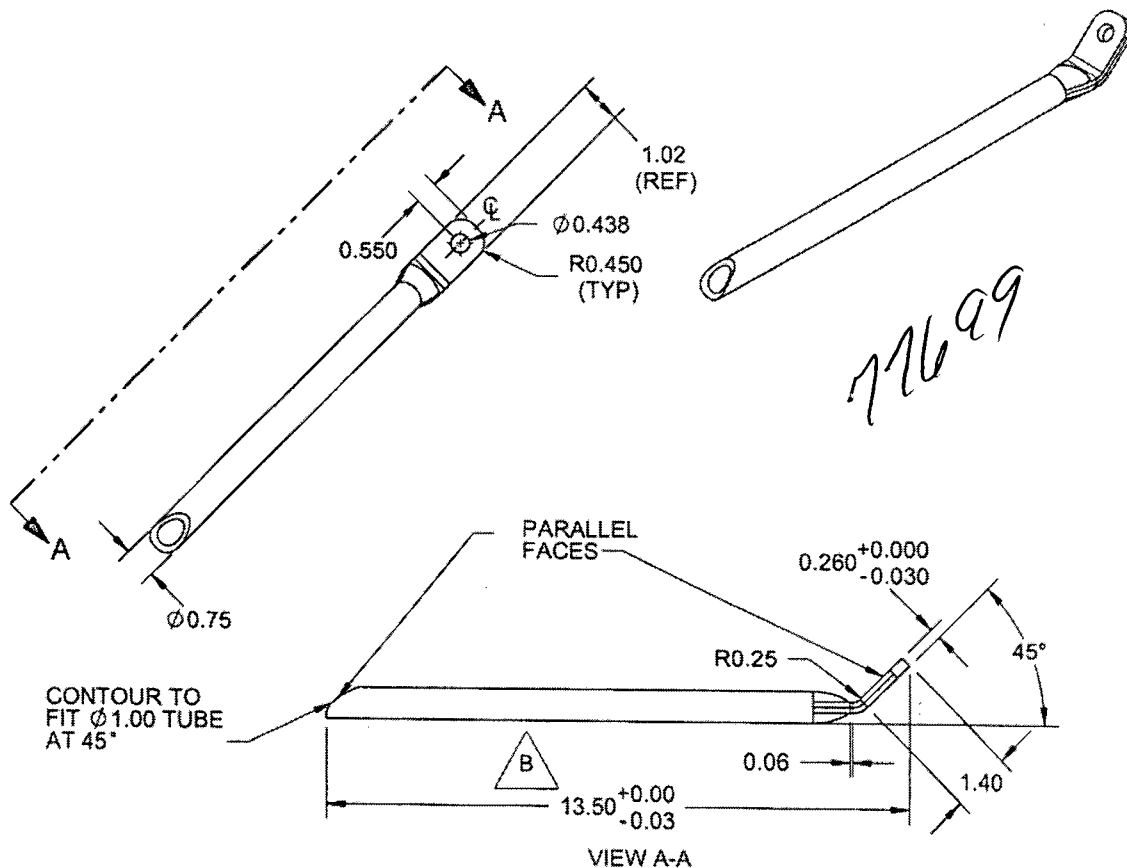
NOTE: Date & initial all entries



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|-------------------------|----------------|--|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3463 | REV. B SHEET 3 OF 4 |
| DATE 05.12.05 | | TITLE STEP WELDMENT | SCALE 1:4 |

RELEASED

05.12.09 #



D3463-7 DRAG ARM

NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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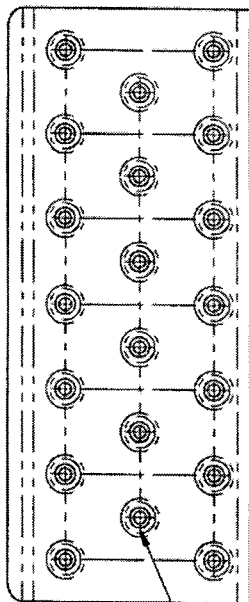
NOTE: Date & initial all entries



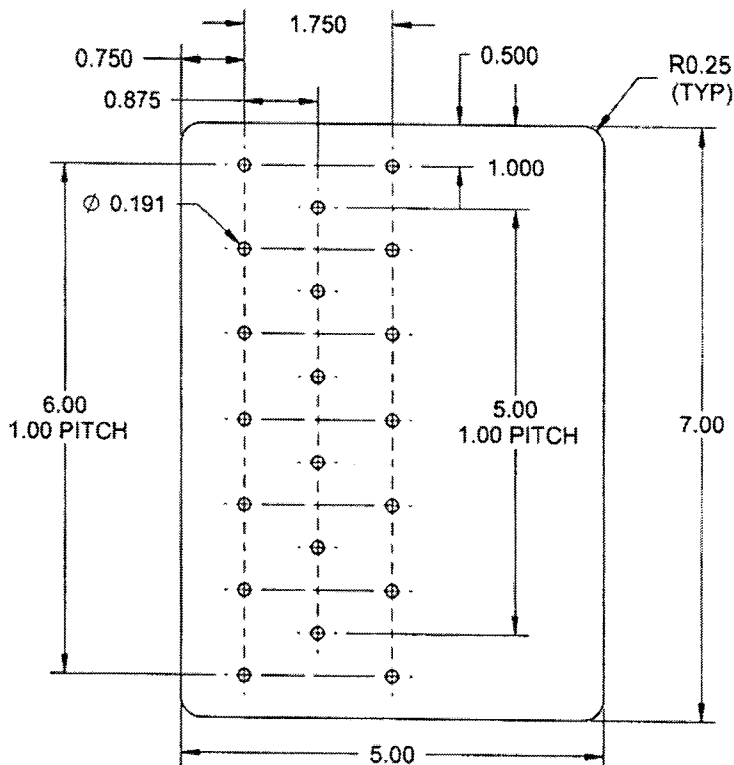
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|-------------------------|----------------|--|------------------------|
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3463 | REV. B SHEET 4 OF 4 |
| DATE 05.12.05 | | TITLE STEP WELDMENT | SCALE 1:2 |

RELEASED

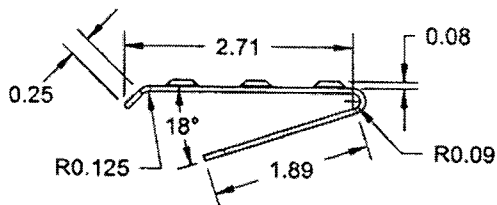
05.12.09 #



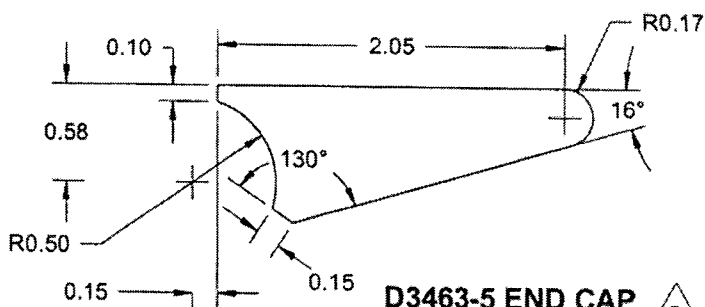
FORM USING
D3463-3T1



D3463-3F FLAT PATTERN



D3463-3 STEP



D3463-5 END CAP
SCALE 1:1



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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